

018454



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

646.9701

Job Sheet 214163



Part No: 646.9701

Job Qty: 2 pcs

Part Name: Cutter Sub Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/20/20

Job Tracking No:

Due Date: 12/18/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.9701 REV.J IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS IPP REV:B AS PER REV D 16-03-07  
JLM VERIFIED BY:JFS IPP REV:C 2020.05.27 AS PER DWG REV.J DD VERF:JFS

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation              | Qty      | Start Date | Due Date | Standard  |         | Workcenter/Supplier         |  | Lead Time | Sign-off           |
|-------|------------------------|----------|------------|----------|-----------|---------|-----------------------------|--|-----------|--------------------|
|       |                        |          |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier       |  |           |                    |
| 110   | Packaging 1 - Pick Kit | 2<br>pcs |            | 12/17/20 | 0.00      | 0.00    | Packaging 1 - SCH-S         |  |           | DAS 58 DEC 03 2020 |
| 120   | Small Fab - 2 - B4B    | 2<br>pcs |            | 12/18/20 | 0.00      | 0.80    | Small Fab - 1 - B4B         |  |           | DAS 58 DEC 03 2020 |
|       |                        |          |            |          |           |         | Small Fab - 2 - B4B         |  |           | 58                 |
|       |                        |          |            |          |           |         | Small Fab - 3 - B4B         |  |           | 9-80               |
|       |                        |          |            |          |           |         | Small Fab - 4 - B4B         |  |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 5 - B4B         |  |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 6 - B4B         |  |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 7 - B4B         |  |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 8 - B4B         |  |           |                    |
|       |                        |          |            |          |           |         | Small Fab - 9 - B4B         |  |           |                    |
|       |                        |          |            |          |           |         | Small Fab - Various 1 - B4B |  |           |                    |
| 130   | QC 5                   | 2<br>pcs |            | 12/18/20 | 0.00      | 0.00    | QC 5 - 10                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 12                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 17                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 18                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 19                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 22                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 24                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 3                    |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 43                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 49                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 51                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 58                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 68                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 9                    |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 50                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 30                   |  |           |                    |
|       |                        |          |            |          |           |         | QC 5 - 40                   |  |           | DAS 40 DEC 03 2020 |
|       |                        |          |            |          |           |         | QC 5 - 61                   |  |           | 9-89               |



**Container No: S317855**



**Part: 646.9701**  
**Job No: 214163**  
**Serial No/Batch: S317855**  
Revision: REV.J  
Inspector:  
Exp Date:  
Instructions:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K64 1K7  
CANADA  
TEL.: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Date: 12/03/20



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
CANADA  
TEL: 1 613 632-5200  
Email: sales@dartaero.com  
www.dartaerospace.com

Container No: S317855



Part: 646.9701

Job No: 214163

Serial No/Batch: S317855

Revision: REV.J

Inspector:

Exp Date:

Instructions:

Date: 12/03/20

Plex 10/20/20 9:05 AM Dart.lajeunesse.marie



|     |                             |          |          |           |                         |                    |
|-----|-----------------------------|----------|----------|-----------|-------------------------|--------------------|
| 140 | Packaging 3-1 - Stock - B4B | 2<br>pcs | 12/18/20 | 0.00 0.00 | QC 5 - 81               |                    |
|     |                             |          |          |           | QC 5 - 82               |                    |
|     |                             |          |          |           | Packaging 3 - 1 - B4B   |                    |
|     |                             |          |          |           | Packaging 3 - 2 - B4B   |                    |
|     |                             |          |          |           | Packaging 3 - 3 - B4B ✓ | DEC 04 2020 DAS 80 |
|     |                             |          |          |           | Packaging 3 - 4 - B4B   | 9-89               |
|     |                             |          |          |           | Packaging 3 - 5 - B4B   |                    |
|     |                             |          |          |           | Packaging 3 - 6 - B4B   |                    |
|     |                             |          |          |           | Packaging 3 - 7 - B4B   |                    |
|     |                             |          |          |           | Packaging 3 - 8 - B4B   |                    |
|     |                             |          |          |           | Packaging 3 - 9 - B4B   |                    |
|     |                             |          |          |           | Packaging 3 - 10 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 11 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 12 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 13 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 14 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 15 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 16 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 17 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 18 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 19 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 20 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 21 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 22 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 23 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 24 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 25 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 26 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 27 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 28 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 29 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 30 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 31 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 32 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 33 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 34 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 35 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 36 - B4B  |                    |
|     |                             |          |          |           | Packaging 3 - 37 - B4B  |                    |
| 150 | QC 21 - SA                  | 2<br>pcs | 12/18/20 | 0.00 0.00 | QC 21 - SA - 21         | DAS 21 DEC 04 2020 |
|     |                             |          |          |           | QC 21 - SA - 70         | 9-89               |
|     |                             |          |          |           | QC 21 - SA - 9          |                    |
|     |                             |          |          |           | QC 21 - SA - 77         |                    |
|     |                             |          |          |           | QC 21 - SA - 28         |                    |

Part Op 110 - (Pick Kit)  
 Descriptions: 120 - (Small Fab) Assemble as per dwg and apply loctite 598 on all faying surfaces per note . A/R RTV LOCTITE  
 598: \_\_\_\_\_ exp. date: \_\_\_\_\_  
 130 - (QC5- Inspect part completeness to step on W/O)  
 140 - (Identify as per dwg & Stock Location: \_\_\_\_\_) \*\*\*IDENTIFY AS PER IAW MPP-120\*\*\*  
 150 - (QC21- Final Inspection - Work Order Release)

### Job BOM

| Part / Item         | Component Name    | Quantity      | Operation                  | Container |
|---------------------|-------------------|---------------|----------------------------|-----------|
| 646.9710 112        | Body              | 2 pcs (1 ea)  | 110-Packaging 1 - Pick Kit | 5370828   |
| 646.9711 107        | Blade             | 4 pcs (2 ea)  | 110-Packaging 1 - Pick Kit | 5307784   |
| MS21042L08 303      | Nut               | 12 Ea (6 ea)  | 110-Packaging 1 - Pick Kit | 5307361   |
| MS27039-08-19 6A015 | Screw             | 12 Ea (6 ea)  | 110-Packaging 1 - Pick Kit | 5316219   |
| NAS1149FN832P 26A   | Washer (AN960-8 ) | 24 Ea (12 ea) | 110-Packaging 1 - Pick Kit | 5316423   |



| Job Allocations                    |                |          |           |           |
|------------------------------------|----------------|----------|-----------|-----------|
| Operation                          | Component Part | Required | Inventory | Allocated |
| 110-Packaging 1 - Pick Kit         | 646.9710       | 2        | 16        | 0         |
|                                    | 646.9711       | 4        | 26        | 0         |
|                                    | MS21042L08     | 12       | 502       | 0         |
|                                    | MS27039-08-19  | 12       | 405       | 0         |
|                                    | NAS1149FN832P  | 24       | 1,219     | 0         |
| Part Specifications                |                |          |           |           |
| Specifications could not be found. |                |          |           |           |

Plex 10/20/20 9:05 AM Dart.lajeunesse.marie

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QS1042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |